



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

Dec 12/13

RBE117-12010W66-5
Job Sheet 185674



Part No: RBE117-12010W66-5

Job Qty: 40 ea

Part Name: Ring Link



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE117-12010W66 Rev. 1 IPP Rev. A 18.09.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		11/23/18	0.00	0.00	Start Up Waterjet		Dec 18/11/03
110	Waterjet - Omax - 1	40 pcs		11/23/18	0.00	3.33	Waterjet 2 OMAX		Dec 18/11/03
120	QC	40 pcs		11/23/18	0.00	0.00	QC2 Waterjet-4		Dec 18/11/03
130	Mill Conv	40 pcs		11/23/18	0.00	10.00	Mill Conv 1		SBL 18/11/16
135	QC 2	40 pcs		11/23/18	0.00	0.00	QC2 Machining-5		" "
140	QC	40 pcs		11/23/18	0.00	0.00	QC8 Machining-5		Dec 18-11-21
150	Outsource	40 pcs		11/23/18	0.00	0.00	Outsource12		DEC 18-11-27
160	Packaging	40 pcs		11/23/18	0.00	0.00	Packaging2		DEC 18 2018
170	QC	40 pcs		11/23/18	0.00	0.00	QC6		38
180	Packaging	40 pcs		11/23/18	0.00	0.00	Packaging3-1		DEC 18 2018
190	QC21-SA	40 Ea		11/23/18	0.00	0.00	QC21		DEC 18 2018

Part Op 110 - 1-Cut as per Dwg Dwg Rev: 1 Prog Rev: 1 2-Deburr if necessary (Red Barn folder)
Descriptions: 130 - Face part and ream holes to finished size.

135 -

150 - -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required

GA133

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-HRS-P-0.3125	Hot Rolled Steel Plate 0.3125" (44W)	.1600 sf (.004 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-HRS-P-0.3125	0	17	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			



Container No: S124362



Part: RBE117-12010W66-5

Job No: 185674

Serial No/Batch: S124362

Revision: 1

Inspector:

Exp Date:

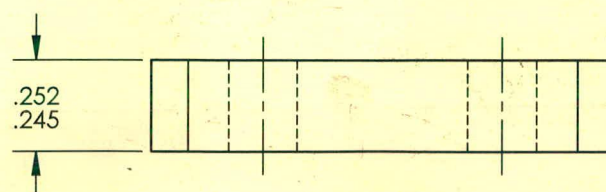
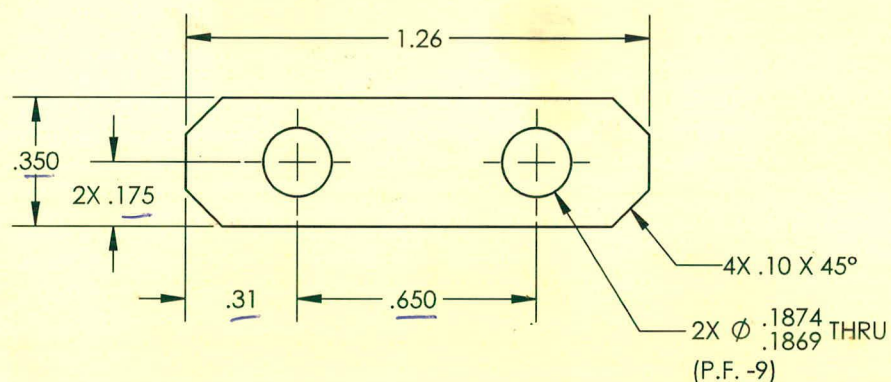
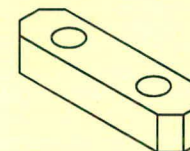
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/04/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 185129 *ms*
187023

(-5)

RING LINK

DART AEROSPACE	
TITLE GUARD	
DWG NO. RBE117-12010W66-5	REV 1
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2 REV D	.X ± .1 SURFACES = 125 ✓
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 2:1	DATE 2/23/2016 SHEET 4 OF 5



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041956**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041956
PO Date: 12/5/18
Due Date: 12/12/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60

Freight Terms:
Special Comments: ** RUSH need for 12/11 or latest 12/12**

revised

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185674	RBE117-12010W66-5	Ring Link -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	12/12/18	39 pcs	0 pcs	39 pcs	\$2.1428571/pcs	\$83.57
							39 x	DEC 18 2018			
2	187389	RBT18560-11	Upright -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	12/12/18	2 pcs	0 pcs	2 pcs	\$2.1428571/pcs	\$4.29
							2 x	DEC 17 2018			
3	178484	RBT18560-11	Upright -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	12/12/18	15 pcs	0 pcs	15 pcs	\$2.1428571/pcs	\$32.14
							15 x	DEC 17 2018			

DAS
38
9-89



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Canada

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PURCHASE ORDER

PO041956

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
										Grand Total:	\$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/10/18 8:32 AM dart.tsimiklis.chrisoula

Certificat de Conformité / Certificate of Compliance

(015097-2)



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

015097 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courrier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
13-Dec-2018		Aman			041956				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBE117-12010W66-5 Rev.	RBE117-12010W66-5 BLACK OXIDE FINISH MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TUPE III OR MIL-C23411A-MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	39	39	0	0	0	

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

